

**Work Order ID 66993**

Thursday, March 03, 2011 10:15:49 AM



Page 1

Item ID: D3295-041

Accept



Setup Start



Revision ID:

Item Name: Floor Window

Stop



Start Date: 3/3/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: *RF*Date: *11-08-3*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								

100



FLOW WATER JET

Waterjet

Memo

0.00

*11-3-8*

FLOW CNC Waterjet

1-Cut as per Dwg D3295  Dwg Rev: *D*  Prog Rev: *D*  2-  
Remove plastic and wrap in saran wrap.  2-Deburr if necessary*(8)*

110



QC2- Inspect parts off machine FAI/FAIB

0.00

*11-3-8*

QC

Memo

0.00

Quality Control

120



QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

*11-03-08**(8)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D3295-041

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Setup

Start



Revision ID:

Item Name: Floor Window

Stop



Start Date: 3/3/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

130

Operation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Small Fab

Small Fab

Small Fab

Memo

0.00

140



QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

150

Identify as per dwg & Stock Location 212

0.00

Packaging

Packaging

Memo

0.00

W/O:		WORK ORDER CHANGES					
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**Work Order ID 66993**

Thursday, March 03, 2011 10:15:50 AM



Page 3

Item ID: D3295-041

Accept



Setup Start



Revision ID:

Item Name: Floor Window

Stop



Start Date: 3/3/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
Description

160

QC21- Final Inspection - Work Order Release



QC

Quality Control

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

0.00

11/3/11

MF  
11-03-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

# Picklist Print

Thursday, March 03, 2011 10:15:56 AM

Page 1

Work Order ID: 66993



Parent Item: D3295-041



Parent Item Name: Floor Window

Start Date: 3/3/2011

Required Date: 3/11/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP C 05.06.20 D3295-1 no longer made in-house KJ/JLM  
IPP Rev:D Added DT8822 07-03-20 JLM  
IPP Rev:E Returned Manufacturing In House 07-06-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2728-1		Manufactured		No		100	Each	0.0000	0	0			
Dart Logo label													
MLEXS.125-9034-01		Purchased		No		140	sf	98.8180	1.24	7.831579	16.		

1/8" 9034 Lexan Sheet

Location	Loc Qty	Loc Code
MAT	98.818	
106173	4	
106403	8.65	
115861	86.168	

*106173*

*115861*

*(8)*

W/O:		WORK ORDER CHANGES						
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DART AEROSPACE LTD		Work Order:	66993
Description: Window		Part Number:	D3295
Inspection Dwg:	D3295	Rev:	D

Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.156	+0.005/-0.001	.161	X		V TBOZ	
17.13	+/-0.030	17.13	X		T TBOZ	
10.43	+/-0.030	10.43	X		T	
14.35	+/-0.030	14.35	X		T	
8.98	+/-0.030	8.98	X		T	
0.625	+/-0.010	.621	X		V	
7.109	+/-0.010	7.112	X		T	
15.845	+/-0.010	15.845	X		T	
2.308	+/-0.010	2.309	X		V	
5.420	+/-0.010	5.419	X		T	
9.402	+/-0.010	9.408	X		T	
1.312	+/-0.010	1.311	X		V	
6.260	+/-0.010	6.265	X		T	
12.520	+/-0.010	12.520	X		T	
0.313	+/-0.010	.312	X		V	
3.750	+/-0.010	3.748	X		T	
8.150	+/-0.010	8.150	X		T	
9.006	+/-0.010	9.006	S		T	
0.125	+/-0.010	.123	S		V	

Measured by:	iB	Audited by:	S	Prototype Approval:	N/A
Date:	11-3-8	Date:	11/03/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	P/O D3295-041	KJ/EC/DD

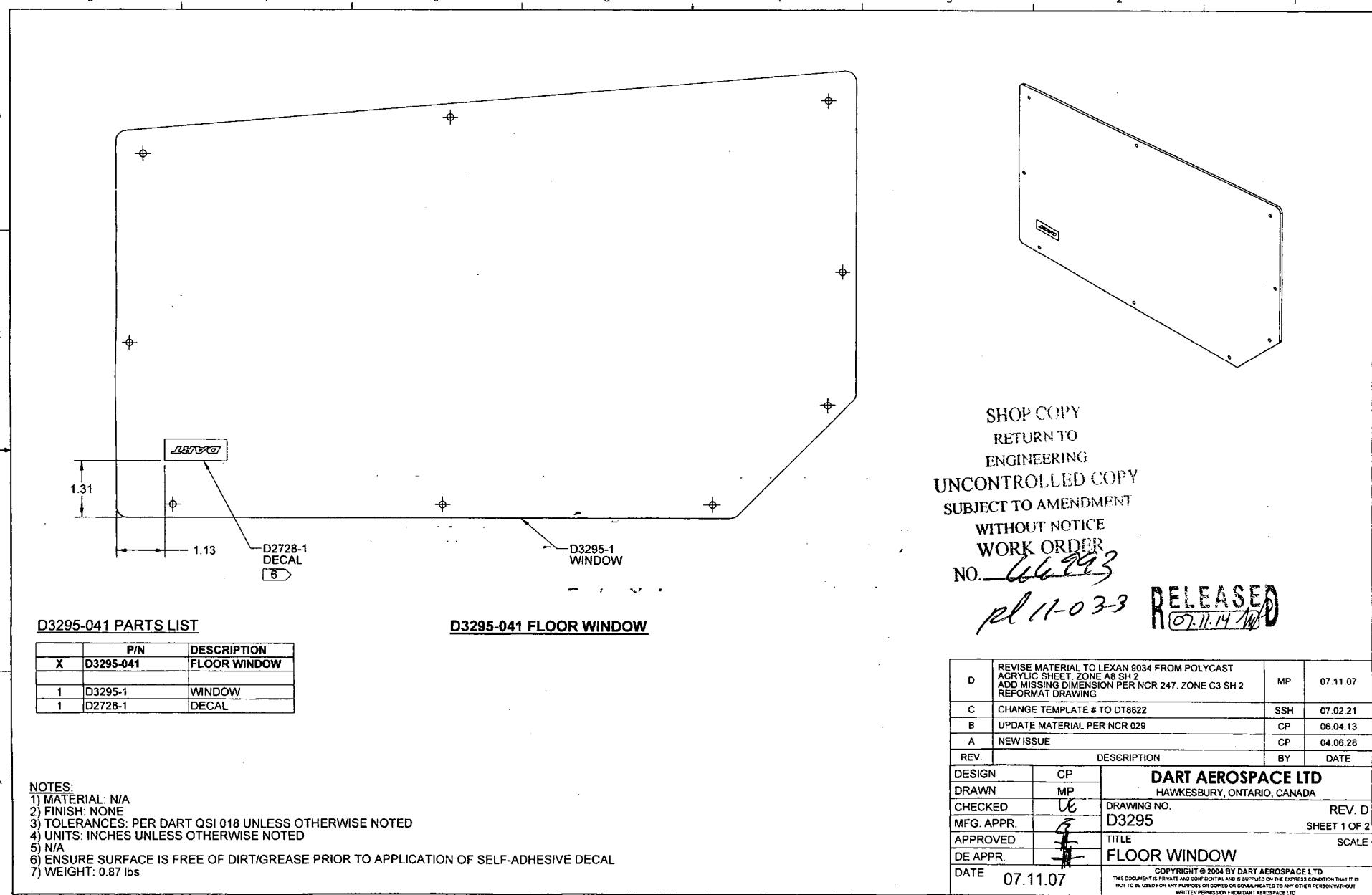
W/O:		WORK ORDER CHANGES					
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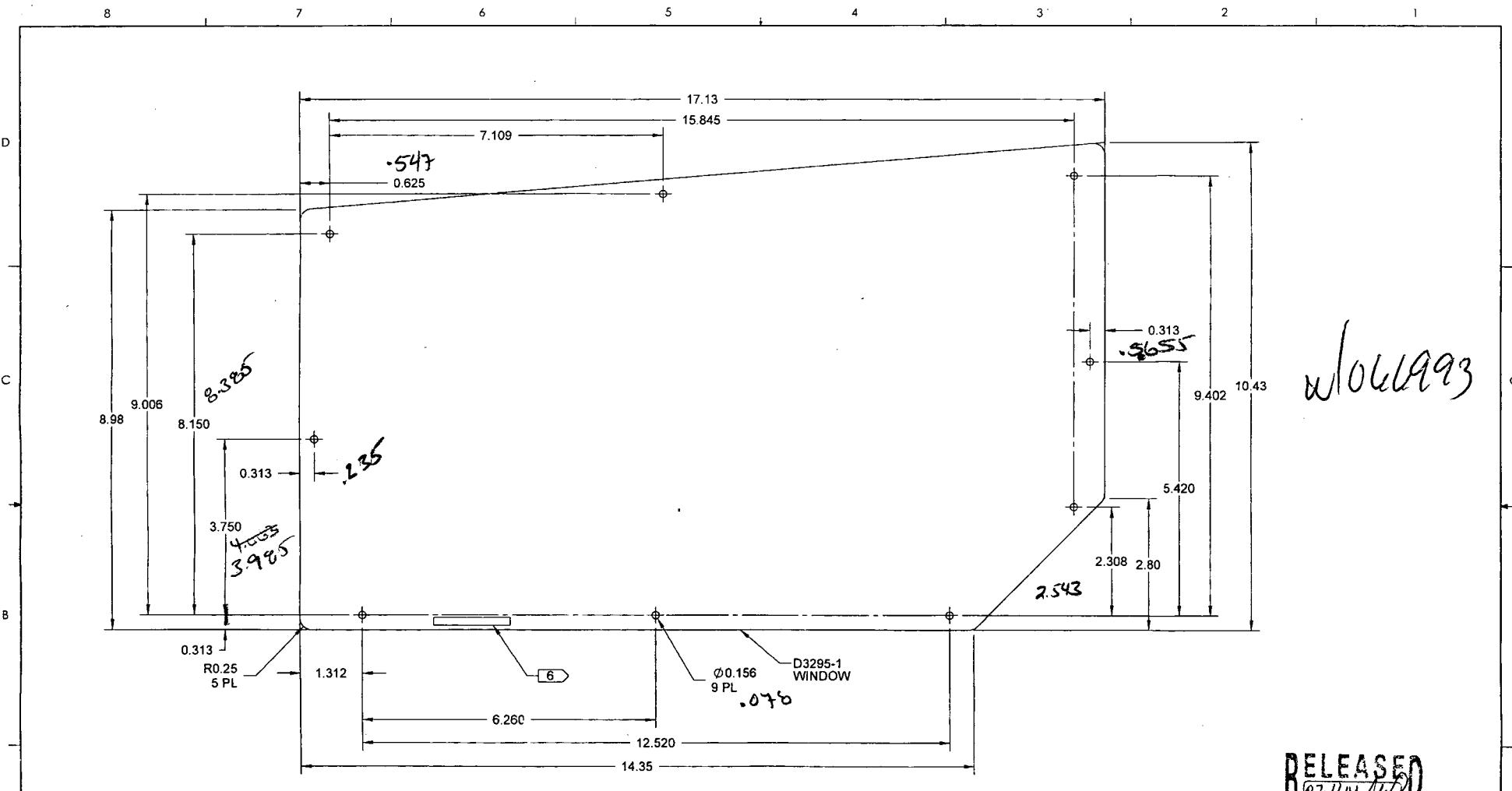
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### D3295-1 WINDOW

#### NOTES:

- 1) MATERIAL: LEXAN 9034, 0.125 THICK (REF DART SPEC. MLEXS.125-9034-01)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N "D3295-041". USE LETTERS 0.125 TO MAX DEPTH OF 0.005 LOCATE APPROXIMATELY AS SHOWN
- 7) WEIGHT: 0.87 lbs

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	MP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	
MFG. APPR.	22	REV. D	
APPROVED	22	D3295	
DE APPR.	22	SHEET 2 OF 2	
DATE	07.11.07	TITLE	
		FLOOR WINDOW	

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